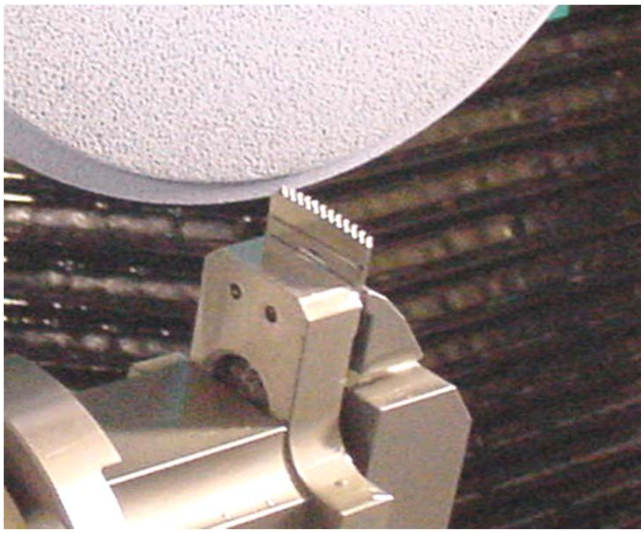
Bone Saw blades

A26-100



Bone Saws for surgical purposes are given in a number of variations and different sizes.
One subtype of bone saws is a bone saw blade, which allows thinner cuts in comparison to rotary cutting discs.
The cutting of the bone (or other material) is performed through oscillation of the blade.
The teeth are ground using a V-shape CBN or ceramic wheel. They can be straight or staggered, straight lined or curved.
Based on selected machine, a number of automatic loading solutions can be offered.

1. Cycletime for Production

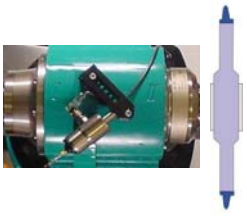
Tool specifications
Bone saw blade, 18 staggered teeth, slightly curved, length of cutting edge 30mm, material HSS

Operations	Probe	Dress	Roughing		Finishing
Feed [mm/Min]	2000	400	300	200	250
Infeed / cycle		0.025	3.000	0.010	0-0.005
Wheel speed [m/s]		33	33	35	35
Used wheels					
Grinding time [s]	30	45	75	60	110
Total cycle time	~ 5.3 min				

The mentioned cycle times are indicative. The material to be ground, different grinding wheels or other coolants can influence the cycle times considerably.

2. Used Grinding Wheels

14E1 Ceramic A120 V40° Ø200mm



3. Machine and Software Requirements

Machines: 5 axes CNC grinder: Aries 5 / Norma CFG / GeminiDMR
Control: Fanuc 31i
Coolant: Synthetic Oil, pressure 6 bar
Software: Quinto 5

responsible engineer: SIW, 09.2010

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